



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3404-1
Job Sheet 177178



Part No: D3404-1

Job Qty: 40 ea

Part Name: Ground Handling Wheel Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/4/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 05.09.01 New issue KJ/JLM IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	6/4/18	6/4/18	0.00	0.00	Start Up Machining-2		DAS 18/05/13
100	Bandsaw	40 pcs	6/4/18	6/4/18	0.00	0.77	Bandsaw1		52 18/05/13
110	CMC Vertical Machining	40 pcs	6/4/18	6/4/18	0.09	18.87	HAAS1-3		9-89
115	Purchasing	40 pcs	6/4/18	6/4/18	0.00	0.00			
121	QC	40 pcs	6/4/18	6/4/18	0.00	0.00			
122	Outsource	40 pcs	6/4/18	6/4/18	0.00	0.00	PO		
125	Packaging	40 pcs	6/4/18	6/4/18	0.00	0.00	Packaging2		CT 18-6-5
130	QC	40 pcs	6/4/18	6/4/18	0.00	0.00	QC6		38 18-06-19
140	Packaging	40 pcs	6/4/18	6/4/18	0.00	0.00	Packaging3-1		9-89
150	QC21-SA	40 Ea	6/4/18	6/4/18	0.00	0.00	QC21		DAS 18/06/22

Metec PO: P0040110

DAS 21 JUN 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B0.750X2.500	304 Bar .750 X 2.50	9.1640 ft (2291 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304B0.750X2.500	9	28	0

Part Specifications

Specifications could not be found.

Plex 5/8/18 10:25 AM Dart.lajeunesse.marie

CUT AT 2.700 long

5048657 5070001

37009
20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Work Order update only

Container No: S070884



Part: D3404-1

Job No: 177178

Serial No/Batch: S070884

Revision:
Inspector:

Date: 05/13/18

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

FAST DEPARTMENT/PROCESS

Tube	Water Jet	Engineering
Fab	Prod. Eng. Coord.	Quality
Finishing	Rec/Store/Packaging	Other
Site	Supplier	

MRB (QS1042) Approval

Position

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

Root Cause

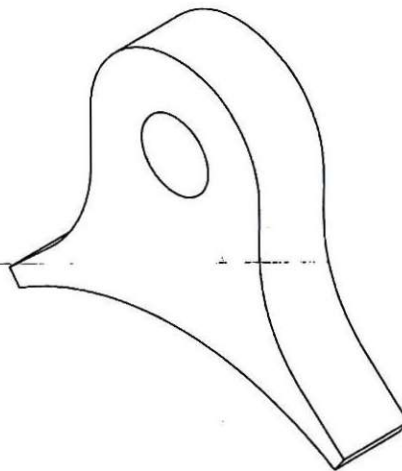
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due				
OTHER :					

77, 78

☒ **First Article** ☐ **Prototype**

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A





D3404-1 GHW LUG

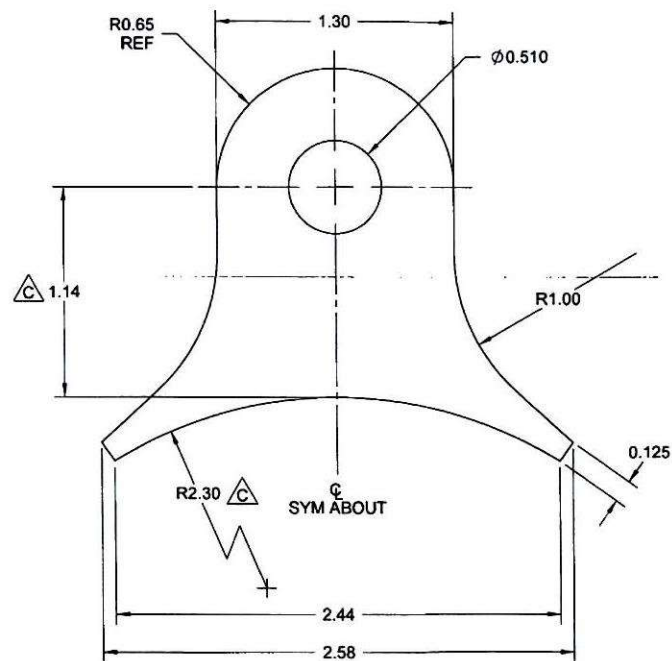
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13718 M5
185508

RELEASED
08/12/18 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.06.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3404	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG	NTS	
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040110

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040110

PO Date: 6/5/18

Due Date: 6/15/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177175	D3278-1	Support	Firmed	6/15/18	40 pcs	0 pcs	40 pcs	\$23.20/pcs	\$928.00
2	177177	D3278-2	Support	Firmed	6/15/18	40 pcs	0 pcs	40 pcs	\$23.20/pcs	\$928.00
3	177178	D3404-1	Ground Handling Wheel Lug	Firmed	6/15/18	40 pcs	0 pcs	40 pcs	\$29.90/pcs	\$1,196.00

Grand Total: \$3,052.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/8/18 11:26 AM dart.tsimiklis.chrisoula



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22789
Date: Jun 15, 2018
Page: 1

Sold to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040110	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Jun 15, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D3278-1 Support, as per drawing D3278 Rev C unpainted		Each	40	40	
D3278-2 Support, as per drawing D3278-2 Rev C unpainted		Each	40	39	
D3404-1 GHW/Lug, as per drawing D3404-1 Rev C unpainted		Each	40	40	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					

DAS
38
9-89

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>BATCH NUMBER</u>	<u>P.O. NUMBER</u>
40	D3278-1	Support	5047296	40110
39	D3278-2	Support	5047296	40110
40	D3404-1	Ground Handling Wheel Lug		40110

DAB
38
9-88

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon, June 15, 2018

Vankleek Hill, May 25, 2018